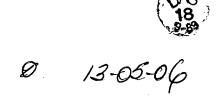
Large Fab 0.00 Memo Large Fab Weld canister assembly as per Dwg D3262 using DT8739 to align fillings



Stamp

PD

Page 1

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00 *110* OC 0.00 Memo Quality Control 120 QC5- Inspect part completeness to step on W/O 0.00QC 0.00 Memo Quality Control Pressure test as per Dwg D3262

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date	
Work Orde	er:					DISPOSITION			***************************************	AGAINST D	EPARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite				Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data]										
Equip/Tooling													
Operator													
Material													
Setup							İ						
Other						,							
Process													
Supplier													
Training					<u> </u>								
Unapproved	ليا	<u> </u>	<u> </u>	L			AIII	T CATE	GORY		1,20	<u> </u>	
Landi				e e e e	· .	General	701			1000 数100 年 100 8 [2]			1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
Lanun	_	Bending		5	Γ-	Bend		Grain	.27的		Ovalized	Γ	Pressure/Forced
	-	Centre No	ot Concer	ntric to		BOM/Route	\vdash	Hardwa	are		Over/Under	tolerance	Temperature/Cure
		Cracks	01 0000.		-/*	Broken/Damaged			ion Incomplete		Part Incorre	ect	Weld
	_	Crushed/	Crimped.			Burrs		1	tions Incomplete/	'Unclear	Part Lost/M	lissing	Wrong Stock Pulled
	\vdash	Cuffs	•			Contamination		Mainte	enance		Part Moved	I	
		Heat Trea	at			Countersink		Mislabe	eled		Positioned	Wrong	
		Inspection	n Strip in	Tube		Cut Too Short		Misrea	d ·		Power Loss	/Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
		Torque W	Vaves in E	xtrusio	n	Drawing		Out of	Calibration				
		Turning S	equence			Finish		Out of:	Sequence				
		Wave/Tw	ist in Tub	oe		Folio	上	Outside	e Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 100784

May 1, 2013 7:19:22 AM

100784

Item ID:

D3262-041

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name: Canister Assembly

Required Date: 4/30/13

4/30/13

Start Qty: 1.00 **Req'd Qty:** 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

OC:

Date:

SPC (Y/N):

Date:

Stop

And the second second

Work Center to

Operation

Description

Sept. \$ 122/ Rua Hours 0.00

Tools Plan Accept Code **Qty**

Reject Qty

Reject Number Stamp

izsp.

130 *130*

HandFinish

Hand Finishing

Memo

Chemical Conversion Coat per QSI005 4.1

0.00

1X \$ M/ 13/05/07

140

140

Powdercoat **Powder Coating**

Memo

****Ensure to mask threa

White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

FINISH TIME:

0.00

0.00

START TIME: **OVEN TEMPERATUR**

150

150 QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

									DQA:	Date:	
NCR: Ye	s / No				WORK ORDER NON-C	ONFORM	MANCE / UP		QA Closed:	Date:	
Work Order:	•		* 1* .		DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
					Rework Skid-tube Crosstube			Water Jet Engineeri			
Part No	·				Scrap	i I	Machining	Small Fab		d. Eng. Coor.	Quality
NCR No). 				Use-as-is Work Order Update	4 1	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	iption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator										•	
Material					•						
Setup											
Other						}					
Process	7										
Supplier											
Training											

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Länding		General	î	1001 # 1001 # 1	(4) <u>(4)</u>	early para	a had to the
	Bending	Bend		Grain		Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	Weld
	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance		Part Moved	
	Heat Treat	Countersink		Mislabeled		Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset			
	Torque Waves in Extrusion	Drawing		Out of Calibration			
	Turning Sequence	Finish		Out of Sequence			
	Wave/Twist in Tube	Folio		Outside Dimensions			

FAULT CATEGORY

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Unapproved

Work Order ID 100784

May 1, 2013 7:19:22 AM

Item ID:

D3262-041

Revision ID: Item Name:

Canister Assembly

Start Date:

4/30/13

QC:

Start Oty: 1.00

Req'd Qty: 1.00

100784

N900040100

Setup Start

Cust Item ID:

Customer:

15 4111

Reference:

Approvals:

Required Date: 4/30/13

Process Plan:

Date: Date: **Tooling:**

Accept

SPC (Y/N):

Date:

Date:

Run

Sequence ID/ Work Center ID: Operation Description

Identify as per dwg & Stock Location:

set to/ Run Hours 0.00

Tool# Plan Code

Accept Qty

Reject Reject Number Stamp

lasp.

160

160

Packaging

Packaging

Memo

0.00

170

QC21- Final Inspection - Work Order Release

0.00

170

Quality Control

QC

Memo

0.00

MUS 13-05-10

NCR: Y	es / No				WORK ORDER NON-O	CONFO	RMANCE / U	JPDATE			
									QA Closed:	Date:	
Work Orde	r:				DISPOSITION	_		- r-	DEPARTMENT,		
Part N	0				Rework Scrap Use-as-is	Th	Skid-tube Machining ermoforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	0	•			Work Order Update]	Large Fab	Composite		Supplier	
Root				Descri	iption of work order update	Initia	1	Action	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng De	escription	Date	Verification	QC inspector
Doc/Data											
quip/Tooling											
Operator										,	
//aterial											
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Other											
rocess						ļ					
Supplier			·								
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Jnapproved						<u> </u>					
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Landin	g Gear				General _{as}			г		·	–
	Bending				Bend	Gra		चित्र सम्बद्धिः । -	Ovalized	_	Pressure/Forced
	Centre N	ot Conce	ntric to (O/S	BOM/Route	⊢	lware	-	Over/Under	⊢	Temperature/Cure
	Cracks				Broken/Damaged	$\boldsymbol{\vdash}$	ection Incomplete		Part Incorre	-	Weld
	Crushed/	Crimped.			Burrs		uctions Incomplet	te/Unclear	Part Lost/M		Wrong Stock Pulled
	Cuffs				Contamination	Mai	ntenance	_	Part Moved		
	Heat Trea	at			Countersink	 	abeled	ļ	Positioned '		- 1
	Inspectio	n Strip in	Tube		Cut Too Short	Misi		L	Power Loss,	/Surge	Other
	Ripples ir	n Bend			Drill Holes	Offs	et				
	Torque V	Vaves in 8	Extrusio	n [_	Drawing	Out	of Calibration				
	Turning S	equence			Finish	Out	of Sequence				
Ţ.	Wave/Tw	ist in Tul	oe		Folio	Out	side Dimensions				

DQA: ____ Date: ___

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

May 1, 2013 7:19:22 AM

Work Order ID:

100784

Parent Item:

D3262-041

Parent Item Name:

Canister Assembly

Comments:

IPP C05.03.10Removed P/O for liquid penetrant

inspectionKJ/JLM

571 DD 10.05.10 verified :EC

Start Date: 4/30/13

Required Date: 4/30/13

Start Qty: 1.00

Required Qty: 1.00

IPP Rev:D as per ECN10-

	571 DD 10.05.10	verified :EC			•									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
D3262-1 Tube		Manufactured	No		•	100	Each	2.0000	1	*	(X) (D)?	7-05-	06	PD
*	•			E neadic		<u> 1/3/98</u> 9	₹ .	Code			÷			
D3262-3		Manufactured	No	date	.	100	Each	4.0000	b954	<u>२८</u> २८	¥(D)			nut siri
Cap		Manuractured	140						2	~ (X 012	,-05°C	96	PD
				Location		Loc Qtv	Lo	c Code						
				WA003	\triangleright	4			SEC.	(2)				

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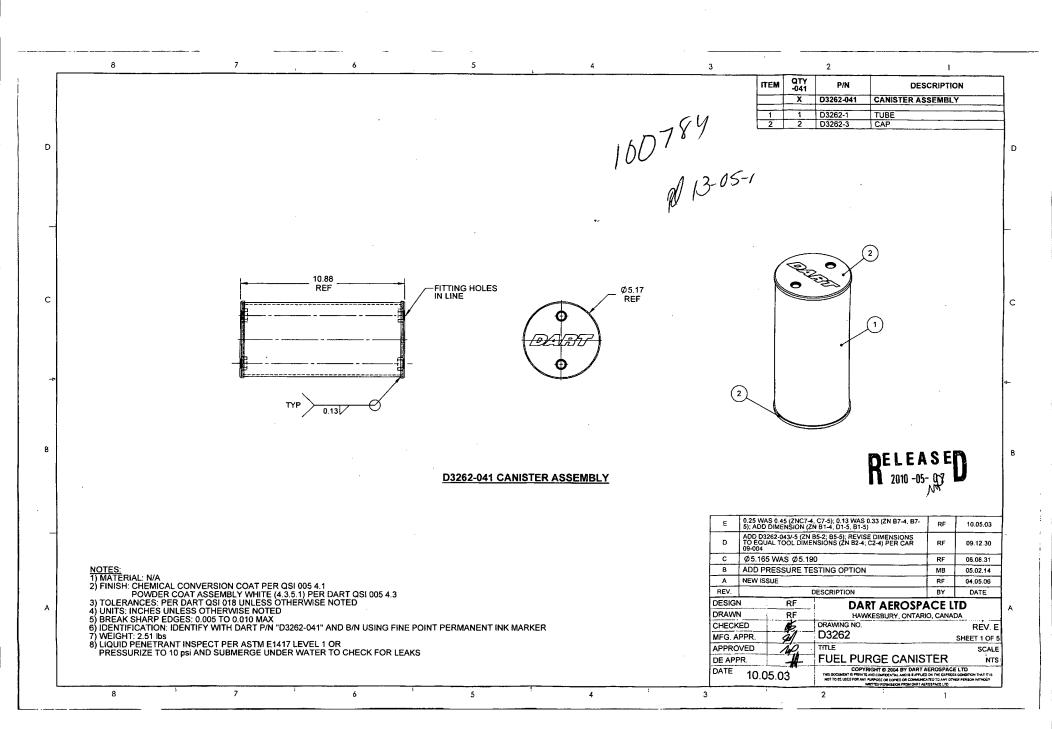
										DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON	-CON	IFORN	MANCE / UPDATE		QA Closed:	Date	::
Work Orde	or:	·			DISPOSITION			AGAIN	ST DE	PARTMENT	PROCESS	
Part N	lo	Rework Skid-tube Crosstube Water Jet Scrap Machining Small Fab Prod. Eng. Coor. Use-as-is Thermoforming Finishing Rec/Store/Packaging Work Order Update Large Fab Composite Supplier					Engineering Quality Other					
Root		<u> </u>		Desc	cription of work order update	lr	nitial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator									,			
Material [<u>.</u>									
Setup [}									
Other		1										
Process												İ
Supplier												
Training												
Unapproved											<u></u>	
	•					FAUL	CATE	GORY				
Landir	ng Gear			_	General					•	_	
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re _.		Over/Under	⊢	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	⊢	Weld
	Crushed	Crimped.			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/M	_	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance		Part Moved		
	Heat Tre	at			Countersink		Mislabe	eled	_	Positioned \		\neg
	Inspectio	n Strip in	Tube	. [Cut Too Short		Misread	t		Power Loss,	/Surge	Other
	Ripples i	n Bend			Drill Holes		Offset				,	
	Torque V	Vaves in I	Extrusio	n [Drawing		Out of (Calibration				
ſ	Turning S	Seguence	•		Finish		Out of 9	Sequence				

Outside Dimensions

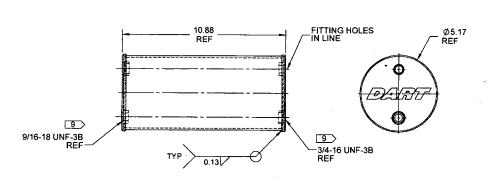
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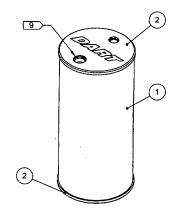
Wave/Twist in Tube

Folio



8 7 5 3 2 QTY -043 ITEM P/N DESCRIPTION D3262-043 CANISTER ASSEMBLY D3262-1 TUBE 100 784 D3262-5 CAP





D3262-043 CANISTER ASSEMBLY

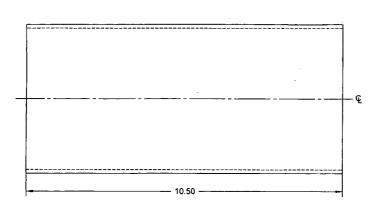
NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-043" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT 2.50 Ibs 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-043" AND B/N USING FINE POIN 7) WEIGHT: 2.50 lbs 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS 9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

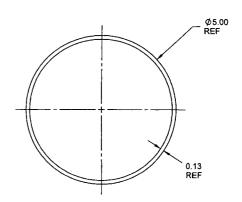
DESIGN	RF	DART AEROSPACE L	.TD
DRAWN	RF	HAWKESBURY, ONTARIO, CANA	
CHECKED	1	DRAWING NO.	REV. E
MFG. APPR.	9/	D3262	SHEET 2 OF 5
APPROVED	10	TITLE	SCALE
DE APPR.	-4	FUEL PURGE CANISTER	NTS
DATE 10.0	5.03	COPYRIGHT © 2004 BY DART AEROSPAC THIS DOCUMENT IS PRIVATE AND COMPIDENTIAL AND IS SUPPLIED ON THE EXPRE NOT TO BE USED FOR ANY PURPOSE OR COMEDIO OR COMMUNICATED TO ANY OF WATTER FIRMSOON FROM DART AEROSPACE UTU.	SS CONDITION THAT IT IS

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D3262-1 TUBE



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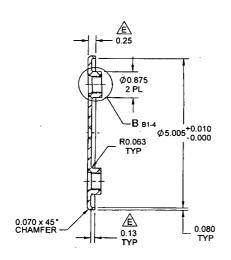
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NOTES: 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T6T5.000W.125

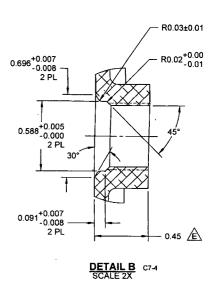
- 2) FINISH: NONE
 3) TOLERANCES: PER DART SPEC. M6061T6T5.000W.125
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 1.96 Ibs.
 8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	DART AEROSPACE I	TD
DRAWN	RF	HAWKESBURY, ONTARIO, CANA	ADA
CHECKED	\$	DRAWING NO.	REV. E
MFG. APPR.	9/	D3262	SHEET 3 OF 5
APPROVED	140	TITLE	SCALE
DE APPR.	#	FUEL PURGE CANISTER	NTS
DATE 10.0	5.03	COPYRIGHT © 2004 BY DART AEROSPAC THIS DOCUMENT IS PRIVATE AND COMPRENTIAL AND IS RUPPLED ON THE EXPRE	ES CONDITION THAT IT IS

7 5 3 2



DRILL THRU Ø0.516 (33/64 DRILL), TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879 Ø5.165 2 PL REF 1.63 Œ. 3.25 REF 6



SECTION A-A C5-4

D3262-3 CAP

NOTES:
1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6B
2) FINISH: NONE
3) TOLERANCES: PER DART OSI 018 LINLESS O

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
7) WEIGHT: 0.28 lbs
8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	DART AEROSPACE L	TD.
DRAWN	RF	HAWKESBURY, ONTARIO, CANAL	DA .
CHECKED	1	DRAWING NO.	REV. E
MFG. APPR.	91	D3262	SHEET 4 OF 5
APPROVED	14	TITLE	SCALE
DE APPR.	-4	FUEL PURGE CANISTER	NTS
DATE 10.0	5.03	COPYRIGHT © 2004 BY DART AEROSPACE THIS DOCUMENT IS PRIVATE AND COMPIDENTIAL AND IS SUPPLIED ON THE EURESIA NOT TO BE USED FOR ANY PURPOSE OR COMBUNICATION AND ANY WRITTEN PERMISSION FROM DAYA PROPERAGE IN	CONDITION THAT IT IS

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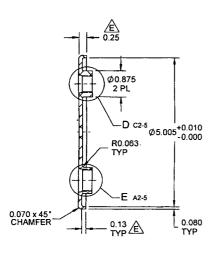
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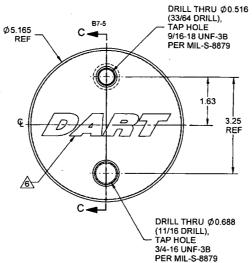
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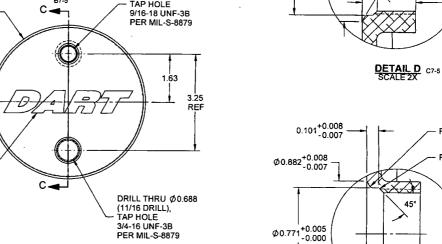
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SECTION C-C D5-5



D3262-5 CAP



3

0.091+0.007

Ø0.696^{+0.007}

 $\phi_{0.588}^{+0.005}_{-0.000}$

DETAIL E B7-5 SCALE 2X

2

R0.03±0.01

R0.02^{+0.00}

R0.03±0.01 - R0.02^{+0.00}

Æ

£

0.45

DESIGN	RF	DART AEROSPACE L	<u>rD</u>				
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA					
CHECKED	45.	DRAWING NO.	REV. E				
MFG. APPR.	9/	D3262	SHEET 5 OF 5				
APPROVED	10	TITLE	SCALE				
DE APPR.	-#	FUEL PURGE CANISTER	NTS				
DATE 10.0	5.03	COPYRIGHT @ 2004 BY DART AEROSPACE THIS DOCUMENT IS PRIVATE AND COMPOSITION AND IS SUPPLIED ON THE EXPRESS HOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMANICATED TO ANY OTHER	CONDITION THAT IT IS				

NOTES: 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T6B

REF. DART SPEC. M606116B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
7) WEIGHT: 0.27 lbs
8) PART IS SYMMETRICAL ABOUT CENTERLINE

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